Monday, 7/30/2007 1:52:24 PM Kim Johnston User **Process Sheet** : PLUG Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 33779 : 12919 **Estimate Number** : D26511UP Part Number P.O. Number AIU: : 7/30/2007 . D2651 REV. B This Issue S.O. No. : NA **Drawing Number** : N/A Prsht Rev. Project Number : MACHINED PARTS : B First Issue **Drawing Revision** A4: : HIA Material Previous Run : 8/20/2007 300 Um: Each **Due Date** Written By Checked & Approved By New Issue 07-07-04 JLM Comment **Additional Product** Job Number: Description: Seq. #: 6061-T6 Round Bar .500" M6061T6R0500 1.0 Comment: Qtv.: 0.0421 f(s)/Unit Total: 12.6315 f(s) Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: 105061 HARDINGE 2.0 Comment: HAAS CNC VERTICAL MACHINING #1 1- Turn as per Folio FA219 and Dwg D2651 2- Deburr 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 5.0 Comment: SMALL & MEDIUM FAB RESOU Deburr ias per dwg D2651

Dart Aerospace Ltd

	WORK ORDER CHANGES								
STEP	1	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			*						
	STEP	STEP					STEP PROCEDURE CHANGE By Date Qty Chief Eng /		

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:) Date: <u>07/08/0</u>
			QA: N/C Closed:	Date:

NCR:			WORK ORD	ER NON-CONFORMANC	CE (NCR)			
	T	Description of NC		Corrective Action Section B	-	Verification	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Monday, 7/30/2007 1:52:24 PM Date: Usei*: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: PLUG Job Number: 33779 Part Number: D26511UP Job Number: Seq. #: Machine Or Operation: Description: HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 Comment: INSPECT POWDER COAT 8.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE u 17.06.24 Job Completion

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W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	:	PAR #: Fault Category: NO	CR: Yes	No DQ	A :	Date:				
			QA:	N/C Close	d:	_ Date: _				

NCR: WORK ORDER NON-CONFORMANCE (NCR							
	Description of NC	Corrective Action Section B		Varification	AI AI		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

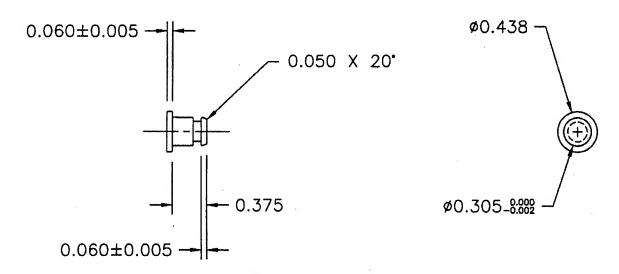




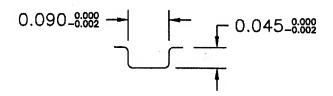
DESIG	A	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	,.
CHEC	(ED,	APPROVED	DRAWING NO.	REV. B
	#	1 At	D2651 SHEET	1 OF 1
DATE			TITLE	SCALE
 03.1	2.19		PLUG	1:1
Α		97.03.25	NEW ISSUE	
В		03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTEDHOP COPY
- 4) ALL DIMENSIONS ARE IN INCHES

5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

1) MATERIAL: BUNA N, 70 DUROMETER 3/16 ID, 5/16 OD, 1/16 WIDTH (PARKER 2-008, MS28775-008 OR EQUIVALENT)

RETURN TO ENGINEERING UNCONTROLLED COPY

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33779) Save

DART AEROSPACE LTD	Work Order:	33349
DART AEROSPACE LIB		D2651-1
Description: Plug	Part Number:	DZUU
		Page 1 of 1

	х	ARTICLE IN			otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comm	ents
0.060	+/-0.005	1000					
C 375	+/-0.010	:375	1				
0.050 x 20°	+/-0.010	1051 XX	1/				
Ø1).305	+0.000/-0.002	20%					
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Rev Date	Change					Revised by	Approve